Dart Aerospace Ltd. Wednesday, 02/04/2008 11:27:30 AM Julie Lecocq **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : BRACKET Job Number : 38296 **Estimate Number** : 12840 P.O. Number : D35421 **Part Number** This Issue : 02/04/2008 S.O. No. : **Drawing Number** : D3542 REV A Prsht Rev. : NC : N/A **Project Number** : // : MACHINED PARTS First Issue 🗼 : A Type **Drawing Revision Previous Run** : 34221 Material 20 Um: Each **Due Date** : 16/04/2008 Qty: Written By Checked & Approved By Comment 07-04-23 : Est Rev. A New Issue JLM EC Est Rev: B updated powder coat per NCR 07.05.16 \*Additional Product Job Number: Seq. #: Machine Or Operation: Description: 1.0 M6061T6B3000X01500 6061-T6 Bar 3" x 1.5" Comment: Qty.: 0.3500 f(s)/Unit Total: 6.9993 f(s) 6061-T6 Bar 3" x 1.5" BATCH: <u>M11.530</u> 2.0 BAND SAW Comment: BAND SAW Cut blank 4.0" long HAAS CNC VERTICAL MACHINING # 3.0  $\mathcal{H}_{pp}$ Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA684 Rev:  $\triangle A$  & Dwg D3542 Rev:  $\triangle$ 2-Deburr per dwg D3443 4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHIN Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 5.0 SECOND CHECK

Comment: SECOND CHECK

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| STEP  | ·                 | PROC      | EDURE CH             | IANGE  |  |                             | Ву   | Date  | Qty  | Approval Chief Eng / Prod Mgr  | Approval<br>QC Inspector   |
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| :     | PAR #: _          | -         | _ Fault Ca           | tegory: _  |  | _ NCF                       | R: Yes   | No DQ   | <b>4</b> :   | _ Date: _  |  |
|       |                   | 1         | . 3                  |  |  |                             | QA: N  | C Close   | d:   | _ Date: _  | ·  |
|       |                   | W         | ORK OR               | DER NO   | N-CONFORM  | ANCE                        | (NCR   | )   |  |  |  |
| 0.750 | Description of NC |           |                      |  |  | tion B                      |  | Verific   | ation  | Approval   | Approval   |
| STEP  | Section A         | i.        | Initial<br>Chief Eng | . Α  | ction Description Chief Eng  |                             | Sign & Date  |   | Section C  | Chief Eng  | QC Inspector   |
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|       |                   | :PAR #: _ | :PAR #:              | :PAR #:Fault Ca  WORK OR  STEP Description of NC Section A Initial | STEP PAR #: Fault Category:  WORK ORDER NO STEP Description of NC Section A Chief Eng Action A | STEP PAR #: Fault Category: | PAR #: Fault Category: NCF  WORK ORDER NON-CONFORMANCE  STEP Description of NC | STEP PAR #: Fault Category: NCR: Yes I QA: N/  WORK ORDER NON-CONFORMANCE (NCR Initial Action Description Sign & Date | STEP PAR #: Fault Category: NCR: Yes No DQU QA: N/C Closer  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B Chief Eng | STEP PROCEDURE CHANGE By Date Qty  PAR #: Fault Category: NCR: Yes No DQA: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC | STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng Proced Myr  PAR #: Fault Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date: QA: N/C Closed: Date: STEP  WORK ORDER NON-CONFORMANCE (NCR)  Corrective Action Section B |

NOTE: Date & initial all entries

Wednesday, 02/04/2008 11:27:30 AM Date: User: Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BRACKET Job Number: 38296 Part Number: D35421 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 7.0 POWDER COATING m 106442 Comment: POWDER COATING Powder Coat Grey sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 \*\*\*\*\*ENSURE TO MASK INSIDE BORE\*\*\*\*\* 8.0 INSPECT POWDER COAT/CHEMICAL CONVERSI Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 243A 10.0 QC21 Comment: FINAL INSE CTION/W/O RELEASE Job Completion

Form: rprocess

Page 2

| Dart Ae | rospace Li                       | ia ·              |                      |                              |                |                           |           |                                     |                          |
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| W/O:    |                                  |                   | WC                   | RK ORDER CHANGE              | <u>S</u>       |                           |           |                                     |                          |
| DATE    | STEP                             | PR                | OCEDURE CHAI         | NGE                          | Ву             | Date                      | Qty       | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|         |                                  |                   |                      |                              |                |                           |           |                                     |                          |
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| Part No | ):                               | PAR #:            | Fault Cate           | jory:                        | NCR: Yes       | No DQA:                   |           | _ Date: _                           |                          |
|         |                                  |                   |                      |                              | QA: N          | /C Closed:                |           | _ Date: _                           |                          |
| NCR:    |                                  |                   | WORK ORDE            | R NON-CONFORMAN              | CE (NCR        | k)                        |           |                                     |                          |
|         |                                  | Description of NC |                      | Corrective Action Section    |                | Verification<br>Section C | ion       | Approval                            | Approval                 |
| DATE    | STEP Description of NC Section A |                   | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date |                           | Chief Eng | QC Inspector                        |                          |
|         |                                  | •                 |                      |                              |                |                           |           |                                     |                          |
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NOTE: Date & initial all entries

| DART AEROSPACE LTD           | Work Order:  | 38296       |
|------------------------------|--------------|-------------|
| Description: Bracket         | Part Number: | D3542-1     |
| Inspection Dwg: D3542 Rev: A |              | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

|         | X First Article Prototype |        |        |        |           |     |
|---------|---------------------------|--------|--------|--------|-----------|-----|
| Drawing | Tolerance                 | Actual | Accept | Reject | Method of | Con |

| Drawing    |                 | Actual     |                                       | Accept Reject Min |   | 0        |
|------------|-----------------|------------|---------------------------------------|-------------------|---|----------|
| Dimension  | Tolerance       | Dimension  | Accept                                |                   |   | Comments |
| Ø2.010     | +0.005/-0.000   | 82.0125    | <b>&gt;</b>                           |                   |   |          |
| Ø2.50      | +0.012/-0.001   | Ø2.502     | \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ |                   |   |          |
| 3.75       | +/-0.030        | 3.750      | /                                     |                   |   |          |
| 2.50       | +/-0.010        | 2.5002     |                                       |                   |   |          |
| 1.00       | +/-0.010        | 1.003      | ~                                     |                   | , |          |
| 0.06 x 45° | +/-0.030 x 0.5° | 0.056 x450 | )                                     |                   |   |          |
| Ø0.266     | +0.006/-0.001   | *272       | <b>/</b>                              |                   |   |          |
| 1.00       | +/-0.030        | 0.999      | >                                     |                   |   |          |
| 0.50       | +/-0.030        | 0.498      | >                                     |                   |   |          |
| 0.500      | +/-0.010        | 0.506      | >                                     |                   |   |          |
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| Measured by: | Y.A/m    | Audited by:   | Prototype Approval: | N/A |
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| Date:        | 08/04/08 | Date: 08/4/08 | Date:               | N/A |

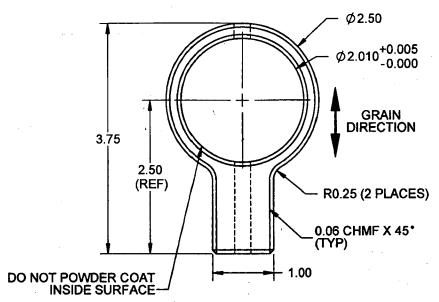
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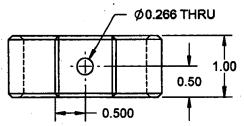
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| CHECK | ED     | APPROVED    | DRAWING NO.                    | REV. A       |
|       | B      | <b>-t</b> t | D3542                          | SHEET 1 OF 1 |
| DATE  |        |             | TITLE                          | SCALE        |
|       | 06.    | 11.27       | BRACKET                        | 2:3          |
| REV   |        | DATE        | DESCRIP                        | TION         |
| A     |        | 06.11.27    | NEW ISSUE                      |              |







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D3542-1 BRACKET



NOTES:

1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART PIN INCLUSE 1 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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